

Date: Wednesday, 1/30/2008 7:56:58 AM  
User: Kim Johnston

## Process Sheet

SPLIT-1

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HANDLE  
Job Number : 37080 - 1  
Estimate Number : 11208  
P.O. Number :  
This Issue : 1/30/2008 S.O. No. :  
Prsht Rev. : NC Part Number : D333015  
First Issue : / / Type : LARGE FAB ASSY Drawing Number : D3330 REV D  
Previous Run : 34198 Drawing Revision : D  
Material :  
Due Date : 2/11/2008 Qty: 10 Um: Each  
Written By :  
Checked & Approved By :  
Comment : Est A 09.01.13 New issue KJ/JLM  
est B 07.05.14 rev C dwg ec  
est C 07.12.12 rev D dwg EC verified by:DD

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M1018R0375 1010-1025 Steel Bar



Comment: Qty.: 0.6999 f(s)/Unit Total : ~~13.9986 f(s)~~  
1010-1025 Steel Bar 6.9993

Material: AISI 1018-1025 0.375" Round Bar cut 8.00" long.  
(M1018-R0.375)

Identify as D3330-15

Batch: ~~M112270~~ B M 106996

2/08/02/26 (10x)

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
Fabricate handle as per Dwg D3330  
Deburr

2/08/02/26 (10x)

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2/08/02/27 (10)

4.0 PACKAGING 1 PACKAGING RESOURCE #1



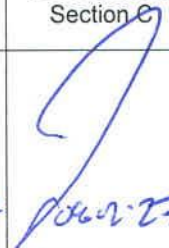




Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: ~~WS21~~

2/08/02/27 (10x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3380-015 PAR #: N/A Fault Category: Prod/FAB. ASS <sup>LARGE</sup> NCR: Yes ☒ No ☐ DQA: 10 Date: 08/02/27  
 QA: N/C Closed: 10 Date: 08/02/27

NCR: <u>37080-1</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/27	20	- Incorrect Mat'l used. - Employee used .3125 instead of .375 for Qty 10 - R.C: Human Error	 08/02/27	- Identify the .3125 material - store for other D-pmts. - Reick the correct mat'l.	 08/02/27	 08/02/27	 08/02/27	 08/02/27

NOTE: Date & initial all entries

Date: Wednesday, 1/30/2008 7:56:59 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE

Job Number: 37080

Part Number: D333015

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

2008/02/27

Job Completion



2008/2/27 (10)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

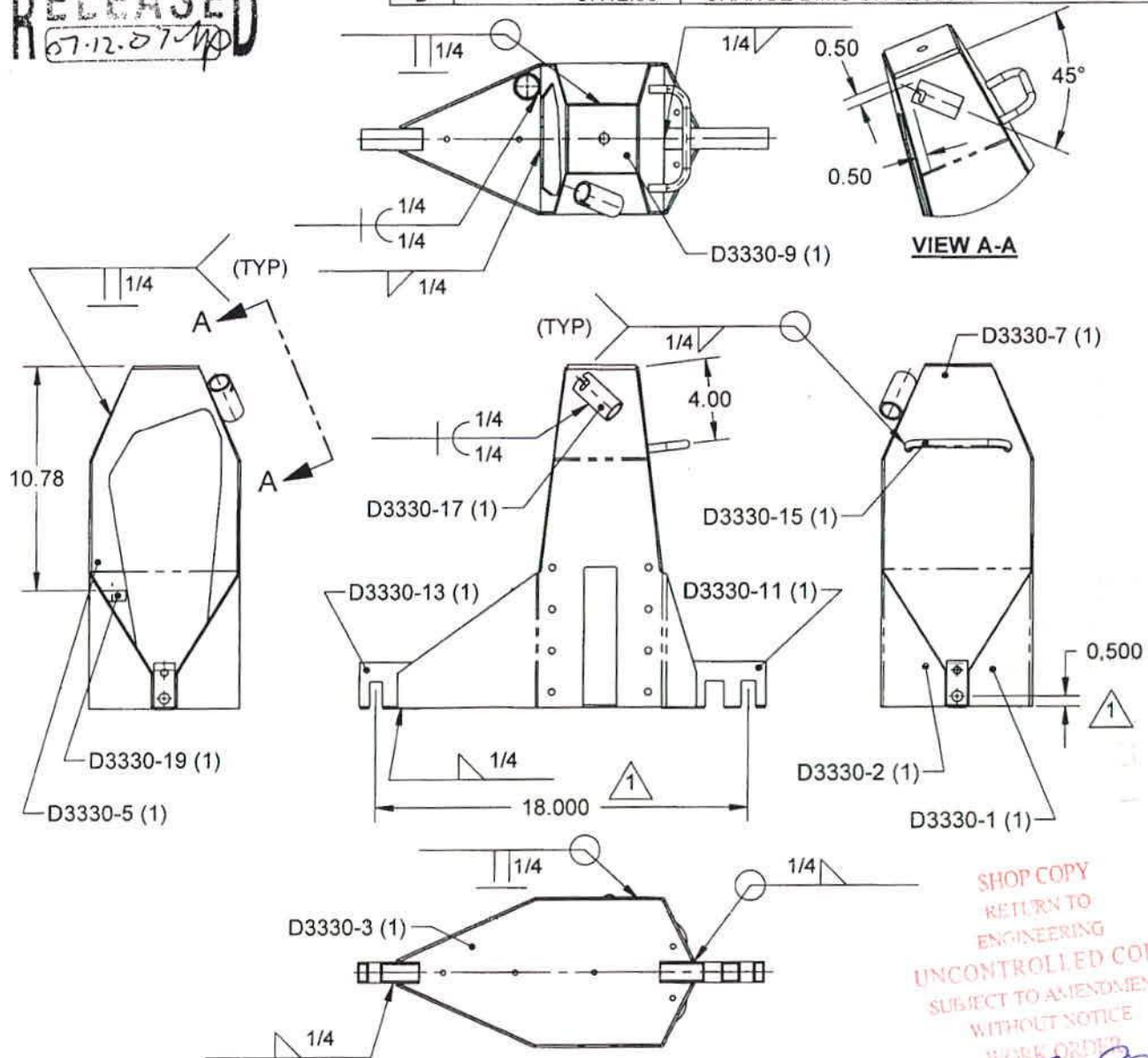
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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DATE <b>07.12.06</b>	TITLE <b>FRAME WELDMENT</b>		SCALE 1:8
REV	DATE	DESCRIPTION	
A	04.12.16	NEW ISSUE	
B	05.02.26	RE-DESIGN	
C	07.03.20	ADD 0.100 DIM; RAISED BEND OF -1/2 BY 0.125	
D	07.12.06	CHANGE DIMS ON D3330-9	

**D3330-041 FRAME WELDMENT****NOTES:**

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

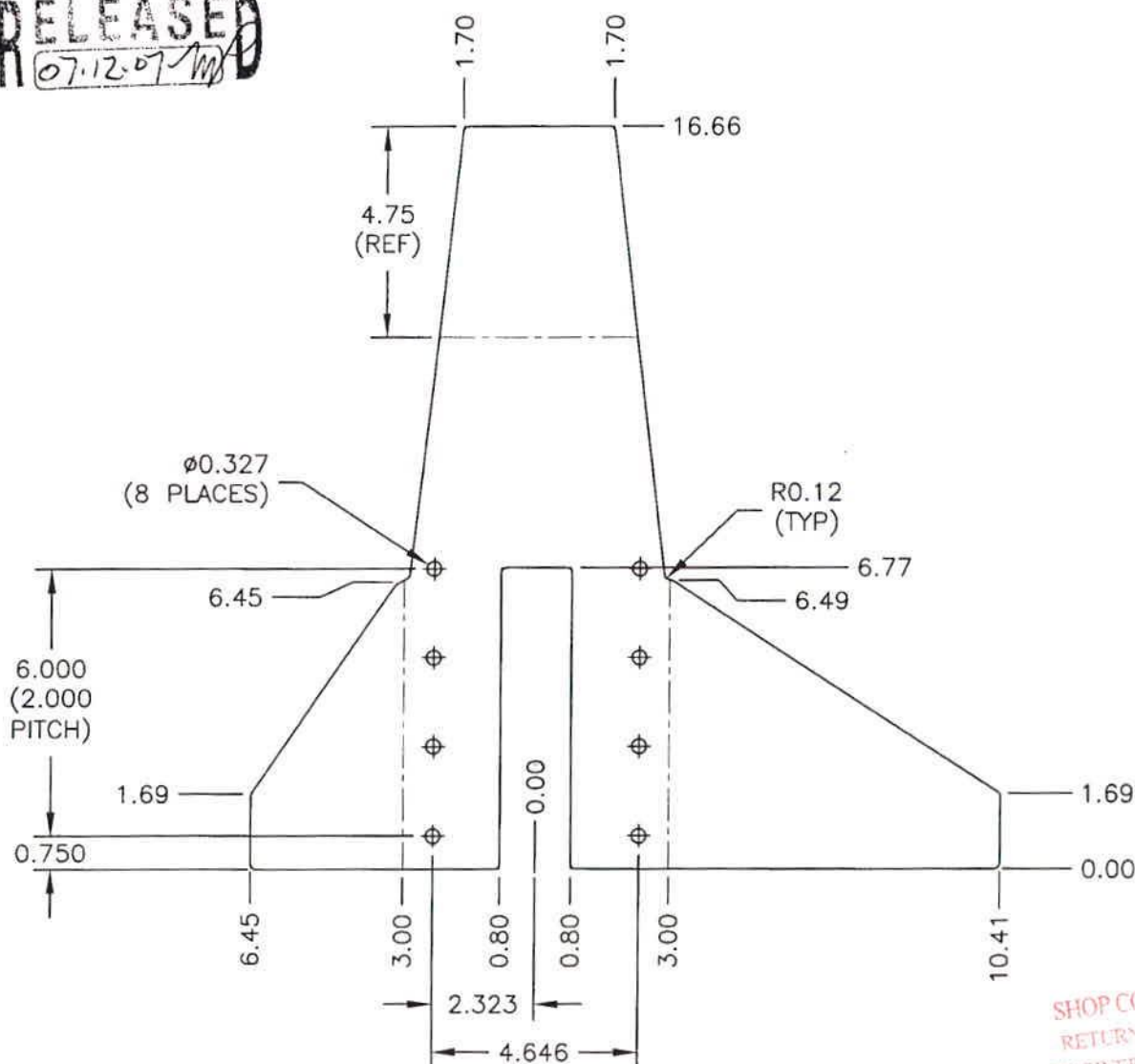
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

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### D3330-1 PANEL

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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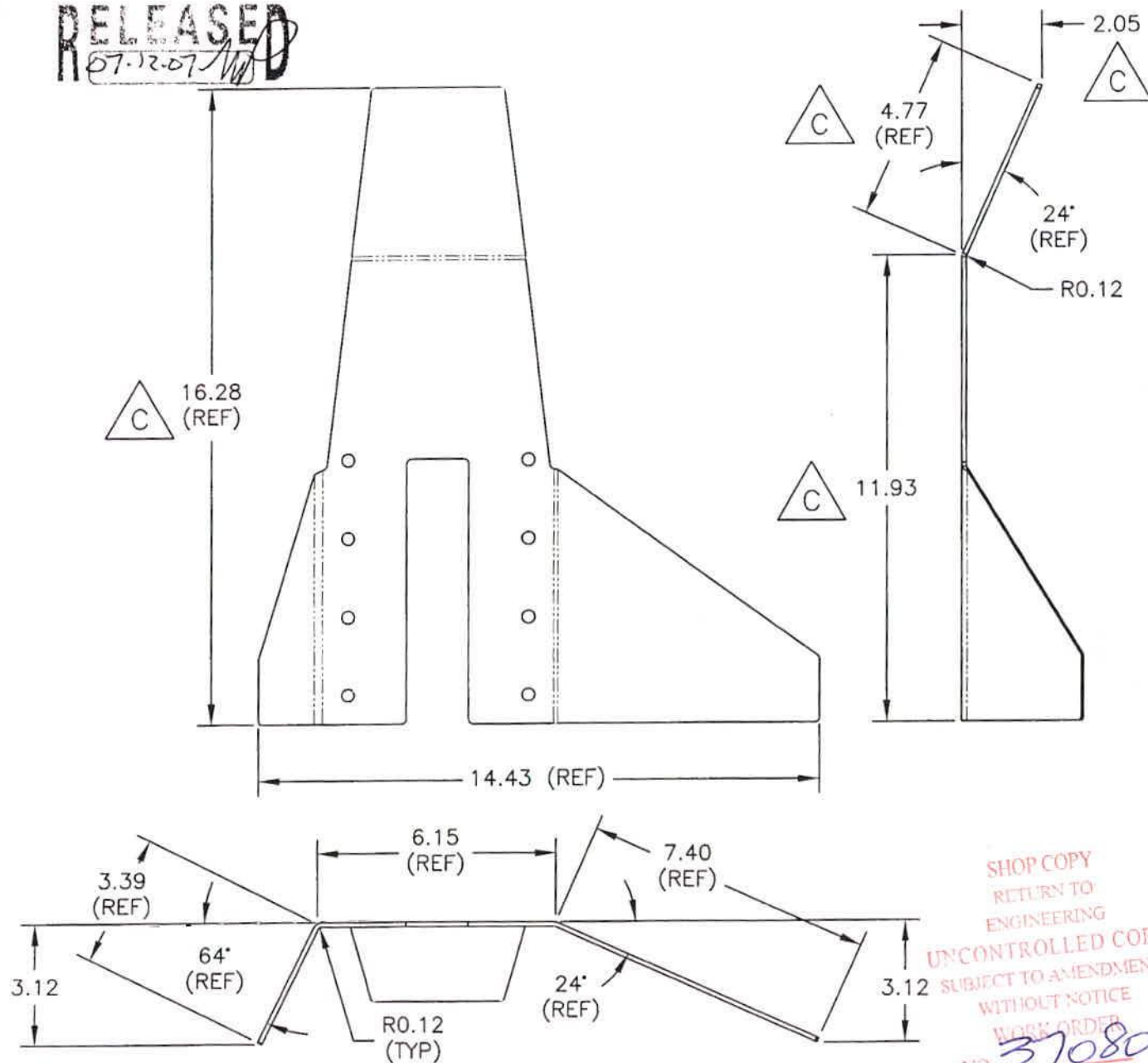
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

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**D3330-1 BEND DETAIL (SHOWN)**  
BEND D3330-2 (OPPOSITE)

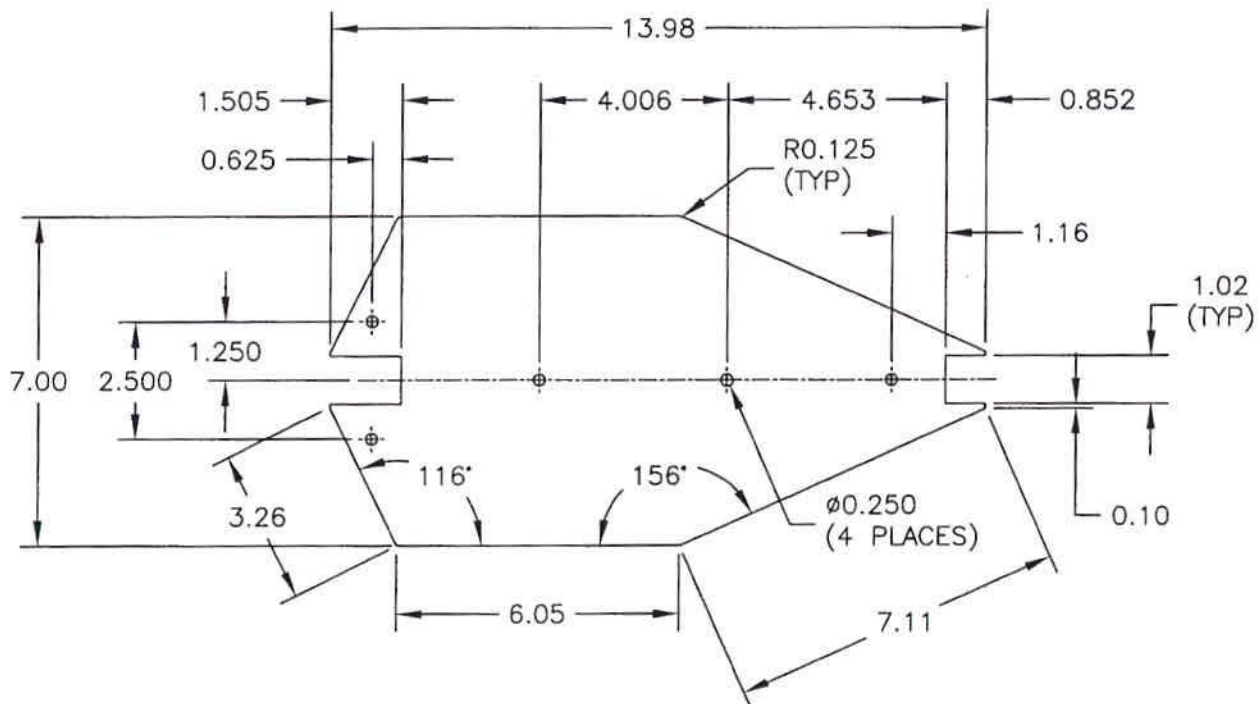
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### D3330-3 PLATE

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#### NOTES:

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- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

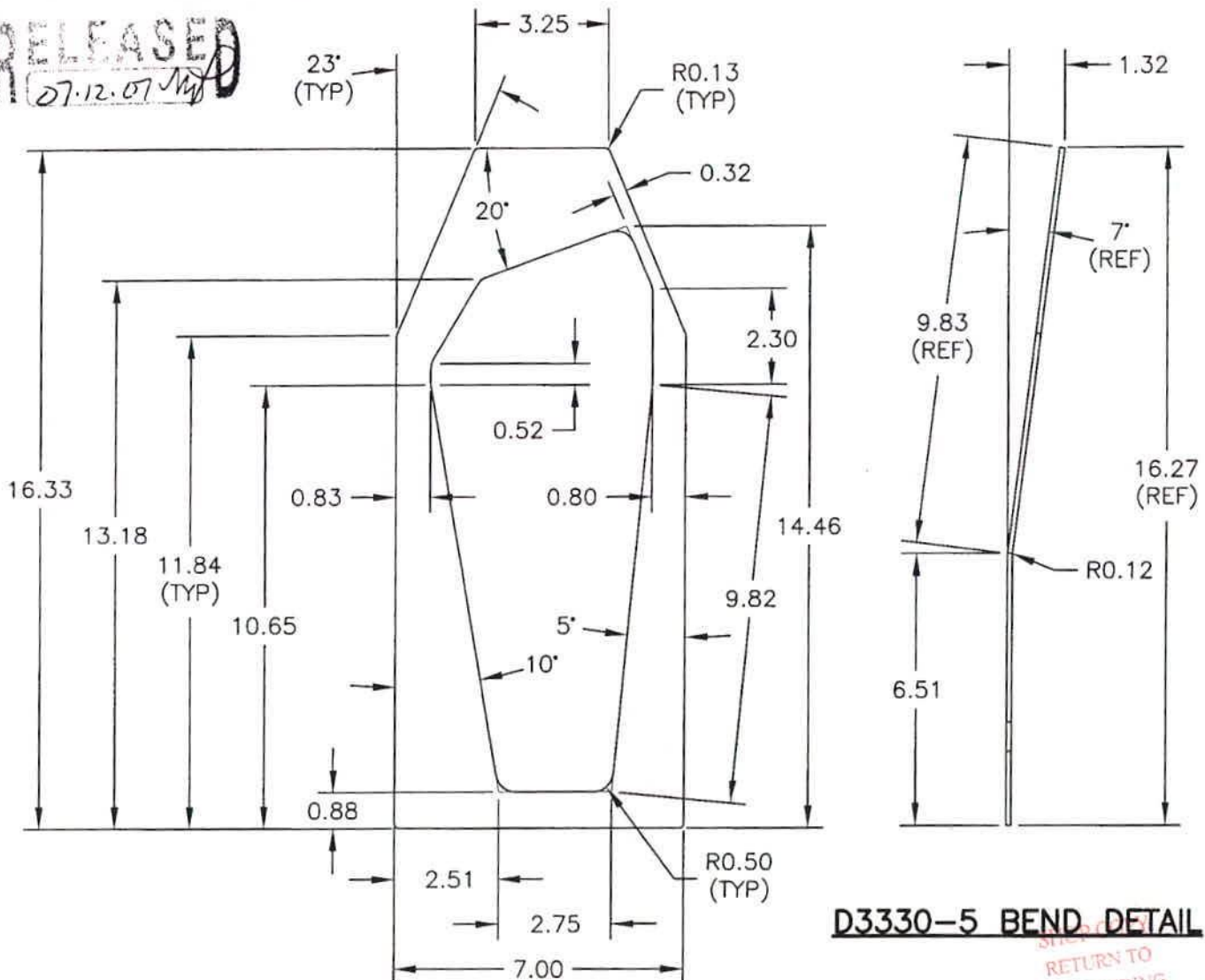
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

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07.12.07 *MD***FLAT PATTERN****D3330-5 BEND DETAIL****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

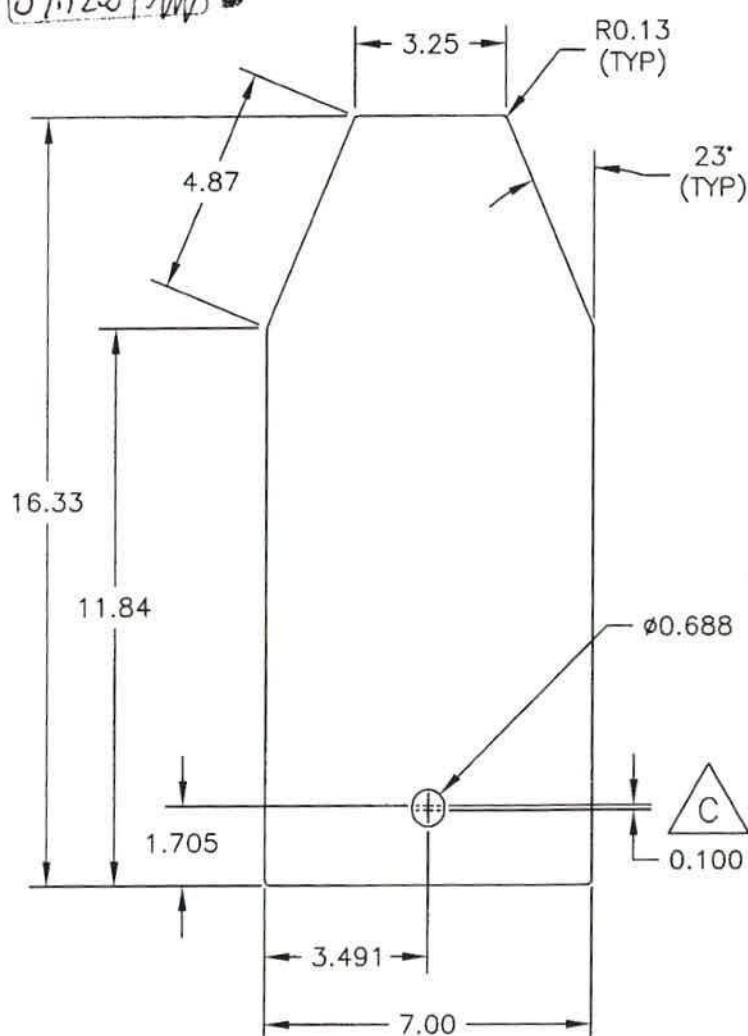
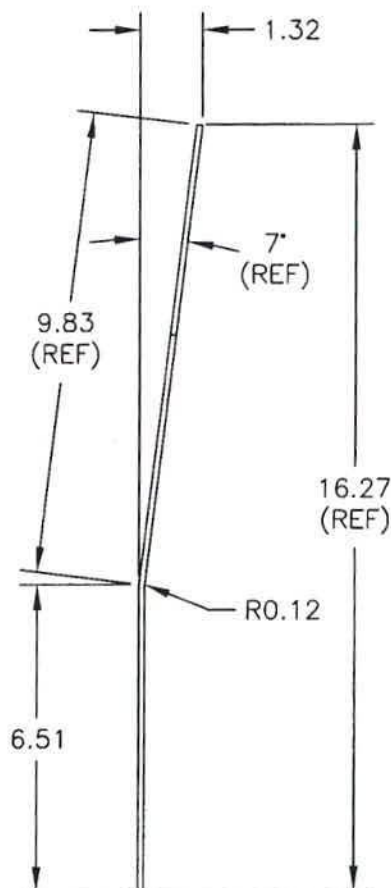
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DATE 07.12.06	TITLE FRAME ASSEMBLY		SCALE 1:4

RELEASED  
07.12.07 MB**FLAT PATTERN****D3330-7 BEND DETAIL****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

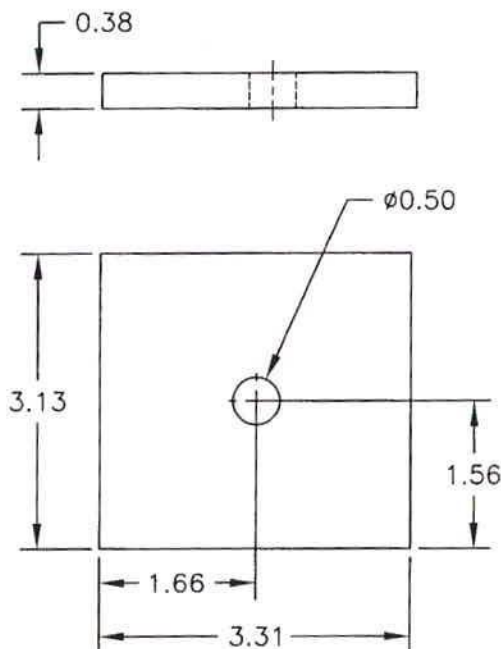
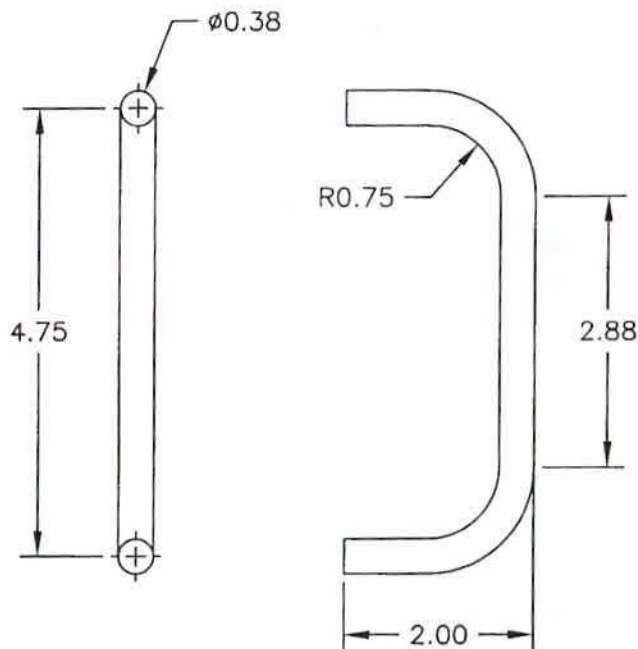
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RELEASED  
07.12.07**1 D3330-9 TOP PLATE****2 D3330-15 HANDLE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL (REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097 (REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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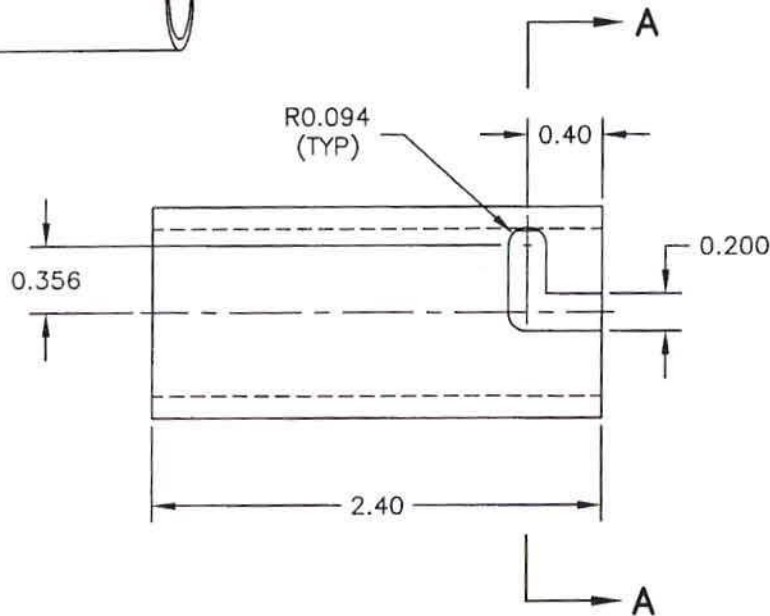
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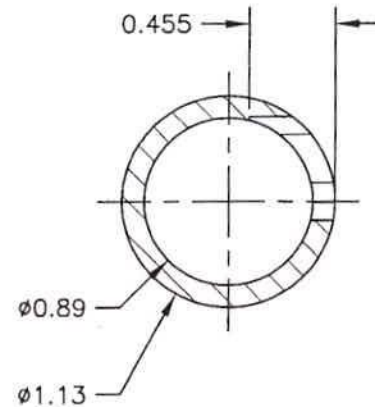




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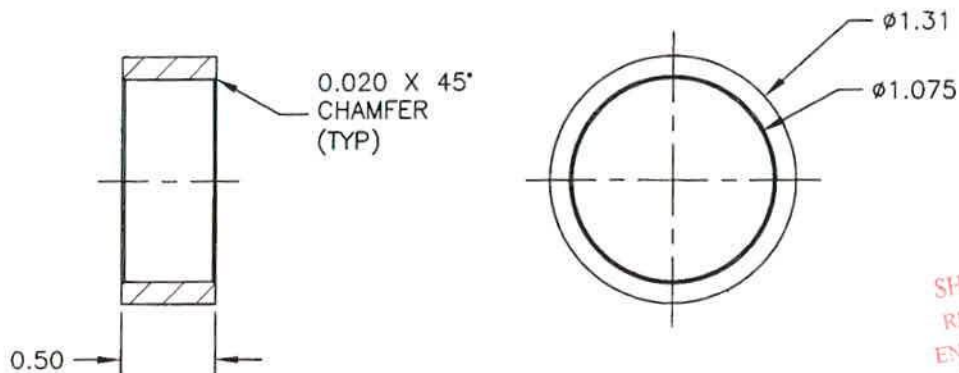


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SECTION A-A

D3330-17 HANDLE SOCKET



D3330-19 HANDLE RIM

NOTES:

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

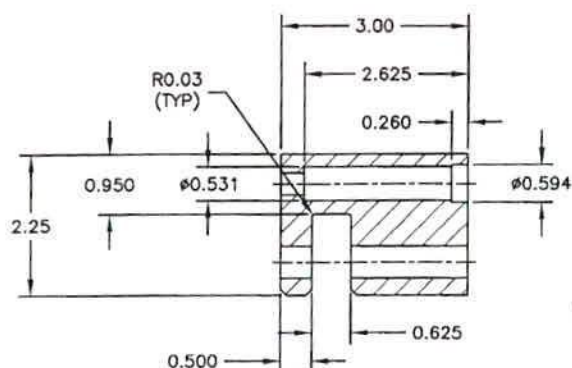
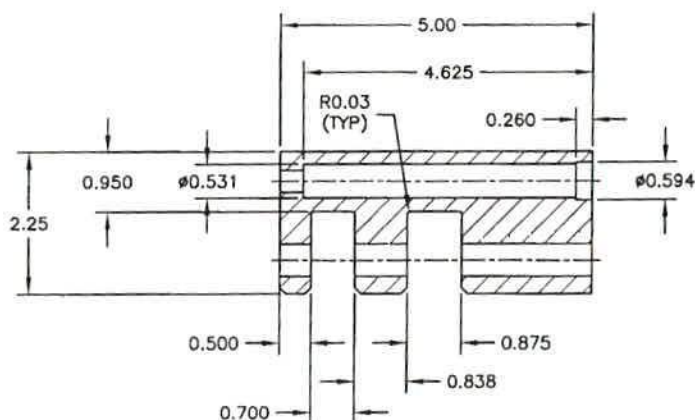
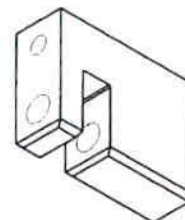
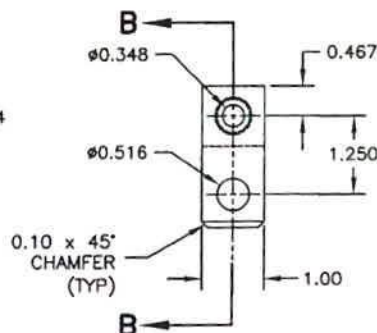
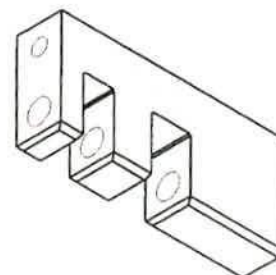
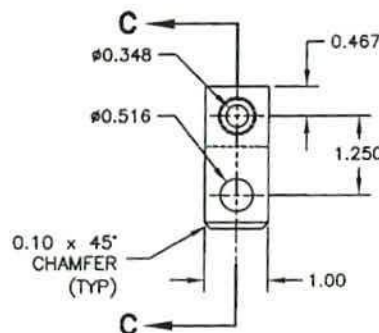
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:3

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07.12.07 *[Signature]***SECTION B-B****D3330-13 SHORT PIN BRACKET****SECTION C-C****D3330-11 LONG PIN BRACKET**SHOP COPY  
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NO. 37080**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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